



Dart Aerospace Ltd.
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D3168-042

Job Sheet 209438



Part No: D3168-042

Job Qty: 1 pcs

Part Name: Step Assembly, Low Short RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/30/20

Job Tracking No:

Due Date: 5/20/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP REV:A 16.03.15 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	1 pcs	5/19/20		0.00	0.10	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
120	QC 6 QC 5	1 pcs	5/19/20		0.00	0.00	QC 6 - 9		
							QC 6 - 68		
							QC 6 - 61		
							QC 6 - 40		
							QC 6 - 81		
							QC 6 - 82		
130	Large Fab - Steps - 2 - B4B	1 pcs	5/19/20		0.00	1.33	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
							Large Fab - 11 - B4B (Various)		
							Large Fab - 12 - B4B		

DAS 82
9-89

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DAS 24
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CANADA
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Container No: S274862



Part: D3168-042

Job No: 209438

Serial No/Batch: S274862

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/30/20

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140 QC 9	1 pcs	5/19/20	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	DAS
				QC 9 - 50	43
				QC 9 - 9	9-89
150 QC 5	1 pcs	5/19/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	DAS
				QC 5 - 49	43
				QC 5 - 51	9-89
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
160 Handfinish - 1-1 Chemical-B4B	1 pcs	5/19/20	0.00 0.17	Handfinish - 1 - 1 - B4B	BER 20-05-12
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
170 QC 7	1 pcs	5/19/20	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	

					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	DAS
					QC 7 - 43	43
					QC 7 - 61	9-89
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
					QC 7 - 83	
					QC 7 - 82	
					QC 7 - 87	
180	Large Fab - Steps - 3 - B4B	1 pcs	5/19/20	0.00 1.33	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	DAS
					Large Fab - 6 - B4B	43
					Large Fab - 7 - B4B	9-89
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
					Large Fab - 12 - B4B	
190	QC 5	1 pcs	5/19/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	DAS
					QC 5 - 51	24
					QC 5 - 58	9-89
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
200	Handfinish - 6-1- Touch Up- B4B	1 pcs	5/19/20	0.00 0.10	Handfinish - 6 - 1 - B4B	BEB 20.05.13
					Handfinish - 6 - 2 - B4B	

				Handfinish - 6 - 3 - B4B	
				Handfinish - 6 - 4 - B4B	
				Handfinish - 6 - 5 - B4B	
				Handfinish - 6 - 6 - B4B	
				Handfinish - 6 - 7 - B4B	
				Handfinish - 6 - 8 - B4B	
				Handfinish - 6 - 9 - B4B	
				Handfinish - 6 - 10 - B4B	
				Handfinish - 6 - 11 - B4B	
				Handfinish - 6 - 12 - B4B	
				Handfinish - 6 - 13 - B4B	
				Handfinish - 6 - 14 - B4B	
				Handfinish - 6 - 15 - B4B	
				Handfinish - 6 - 16 - B4B	
				Handfinish - 6 - 17 - B4B	
				Handfinish - 6 - 18 - B4B	
				Handfinish - 6 - 19 - B4B	
				Handfinish - 6 - 20 - B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	
210	Powdercoat - 1 White Gl(A)- B4B <i>MDS4469</i>	1 pcs	5/19/20	0.00 0.49	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
220	Handfinish - 3-1- WingWalk- B4B	1 pcs	5/20/20	0.00 0.41	Handfinish - 3 - 1 - B4B
					Handfinish - 3 - 2 - B4B
					Handfinish - 3 - 3 - B4B
					Handfinish - 3 - 4 - B4B
					Handfinish - 3 - 5 - B4B
230	QC 3	1 pcs	5/20/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
					QC 3 - 82
					QC 3 - 87
290	Packaging 3-1 - Stock - B4B	1 pcs	5/20/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B

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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
300	QC 21 - SA	1	5/20/20	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53

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Part Op 110 - Fabricate per Drwg - 1-Cut D2622-120C extrusion to 57.090" long as per Dwg D3168

Descriptions: 120 - QC6- All purchased or subcontracted products

130 - Weld per dwg A/R Aluminum rod Batch: _____ - 1-Bevel end for welding FWD ONLY

140 - QC9- Inspect visual per QSI004- Fusion Welds

150 - QC5- Inspect part completeness to step on W/O

160 - Chemical Conversion Coat per QSI005 4.1

170 - QC7-Inspect Chemical Conversion Coat

180 - Weld per dwg A/R Aluminum rod Batch: _____ Rivet Leg Assembly as per Dwg D3168

190 - QC5- Inspect part completeness to step on W/O

200 - Touch up alodine

210 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum - START TIME: _____

220 - Wing Walk as per dwg QSI005 4.4 Batch _____

230 - QC3- Inspect Part Finis

290 - Identify as per dwg & Stock Location: _____

300 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	.5000 pcs (.5 ea)	110-Large Fab - Steps - 1	5243427
D3067-1	End Plate	1 pcs (1 ea)	110-Large Fab - Steps - 1	5267468
D3067-1	End Plate	1 pcs (1 ea)	180-Large Fab - Steps - 3 - B4B	5267468
D3077-1	Step Leg	2 pcs (2 ea)	180-Large Fab - Steps - 3 - B4B	5275314
D3170-1	Spacer	2 pcs (2 ea)	180-Large Fab - Steps - 3 - B4B	52708761
D3219-5	Plate	2 pcs (2 ea)	180-Large Fab - Steps - 3 - B4B	5077391
MS20600-AD4W4	Rivet	12 Ea (12 ea)	180-Large Fab - Steps - 3 - B4B	5251801

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2622-120C	1	264	0
	D3067-1	1	76	0
180-Large Fab - Steps - 3 - B4B	D3067-1	1	76	0
	D3077-1	2	2	0
	D3170-1	2	12	0
	D3219-5	2	31	0
	MS20600-AD4W4	12	1,977	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube Machining ☐ Large Fab ☐ Cross tube Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐							
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042) _____					
Description Work Order Deviation				Disposition							
Completed By				Lead hand / Supervisor							
								QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____						Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	